

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022410**Date Inspected:** 05-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	William Sherwood and Fred Von EWI			EWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder		

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG 9W/10W side plate 'C1' (0mm to 1000mm) inside, QA randomly observed ABF/JV qualified welder Sungtao, Huang ID # 3794 continuing to perform CJP groove (splice) welding fill pass to cover pass on the splice butt joint at the corner with edge plate 'B' where the track mounted Bug-o nozzle holder has limited access. The welder was observed perform manual welding in the 3G (vertical) position utilizing a dual shield Flux Cored Arc Welding (FCAW-G) with E71T-1M, 1/16" diameter wire electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042B-1. The joint being welded has a single V-groove butt joint with backing bar. During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. At the end of the shift, cover pass welding at location mentioned above was completed and the welder informed this QA that he is moving to 10E/11E side plate 'C' inside for his next welding location.

At OBG 10W/11W edge plate 'B' inside, QA randomly observed ABF/JV qualified welder Fred Kaddu continuing to perform fill pass to cover pass back welding on the Complete Joint Penetration (CJP) splice butt joint. The welder was observed manually welding in the 3G (vertical) position utilizing a Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040B. The joint being welded has a single V-groove butt joint with steel backing bar that has been removed and back gouged. The groove of the ground and gouged area of the

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backing bar was also tested and passed using Magnetic Particle Testing (MT). During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. During the shift, cover pass SMAW welding was completed.

At OBG 10W/11W edge plate 'B' inside, QA randomly observed ABF/JV qualified welder Jorge Lopez continuing to perform fill pass to cover pass back welding on the Complete Joint Penetration (CJP) splice butt joint. The welder was observed manually welding in the 3G (vertical) position utilizing a Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040B. The joint being welded has a single V-groove butt joint with steel backing bar that has been removed and back gouged. The groove of the ground and gouged area of the backing bar was also tested and passed using Magnetic Particle Testing (MT). During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters of the welder. At the end of the shift, cover pass SMAW welding was still continuing and should remain tomorrow.

At OBG 10E/11E LS1 longitudinal stiffener inside, ABF welder Hua Qiang Hwang was observed setting up welding equipment/Miller Proheat 35 Induction Heater System in preparation for his next welding location. QA and QC performed a joint fit up verification on the fit up of the joint to be welded. The root gap was noted 3mm wide and the alignment was noted 1.5mm which appears in compliance to the contract requirements. During the shift, the welder was also noted cleaning/grinding the bevel faces of the groove in preparation for the splice welding. There was no welding performed on the stiffener today.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer